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- (57) **ABSTRACT**

- A method and device for nondestructive and noncontact detection of faults in a test piece, or electrically conductive particles in a liquid flow, moving passed the device, using eddy currents. The test piece or flow is exposed to periodic alternating electromagnetic fields. A periodic electrical signal is detected. The receiver coil signal is digitized with an A/D converter stage. A useful signal is produced from the digitized receiver coil signal with a signal processing unit, and the useful signal is evaluated with an evaluation unit for detecting a fault in the test piece or electrically conductive particles. When overdriving of the A/D converter stage by the receiver coil signal is ascertained by monitoring the curve shape of the digitized receiver coil signal, a part of the receiver coil signal truncated by the A/D converter stage is reconstructed using a mathematical approximation in the digitized receiver coil signal.

- 9 Claims, 4 Drawing Sheets**

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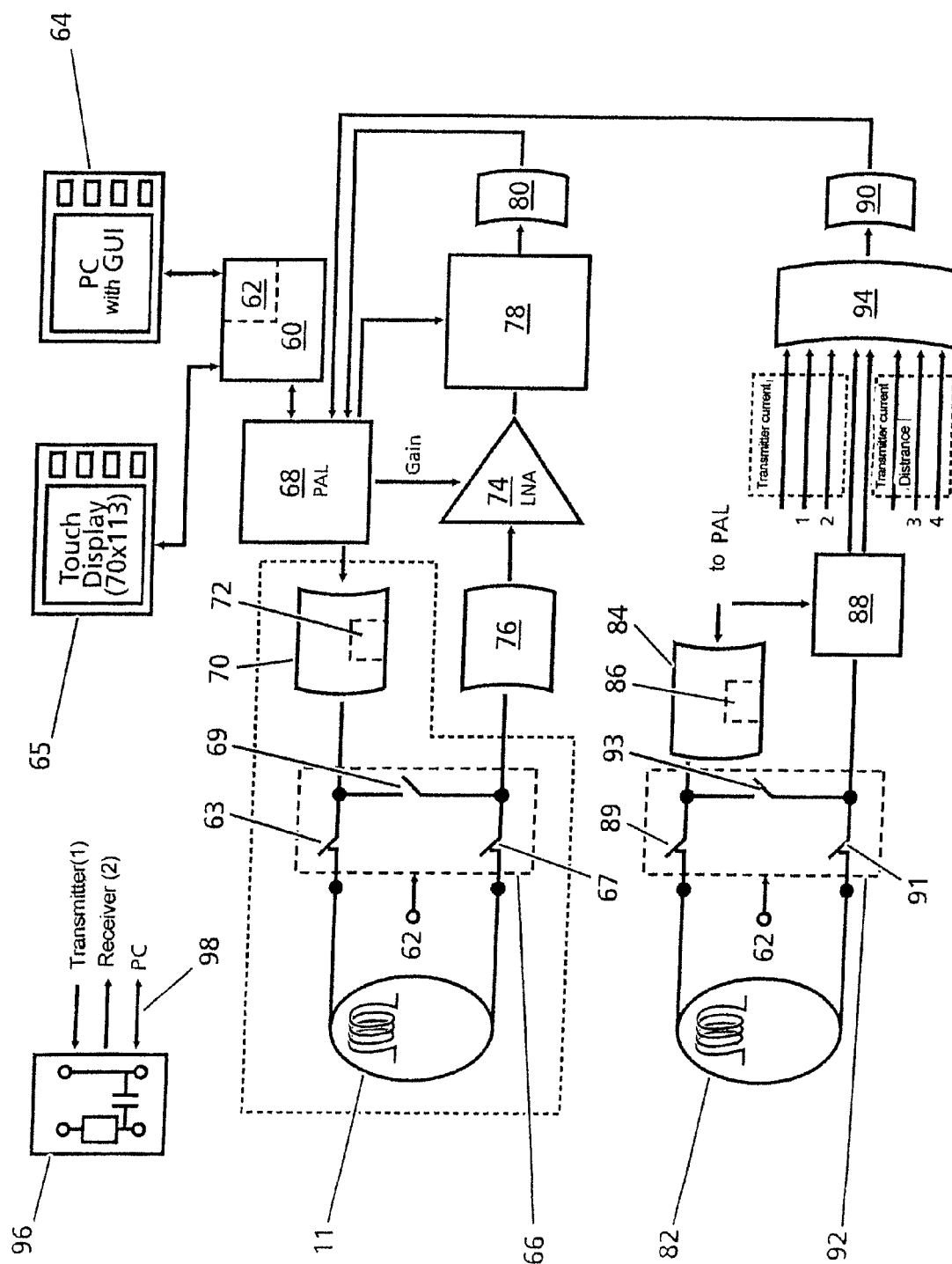


Fig. 1

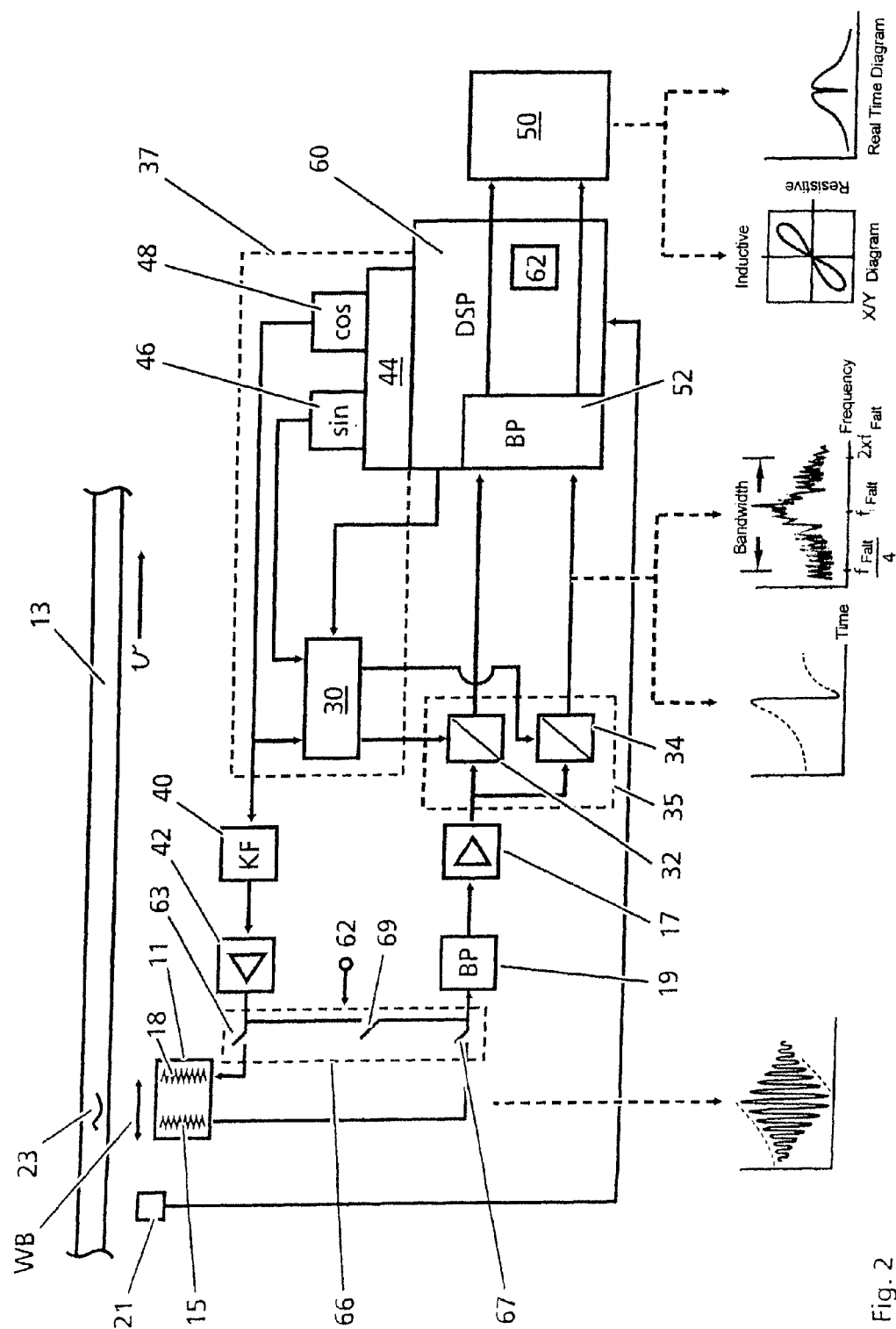


Fig. 2

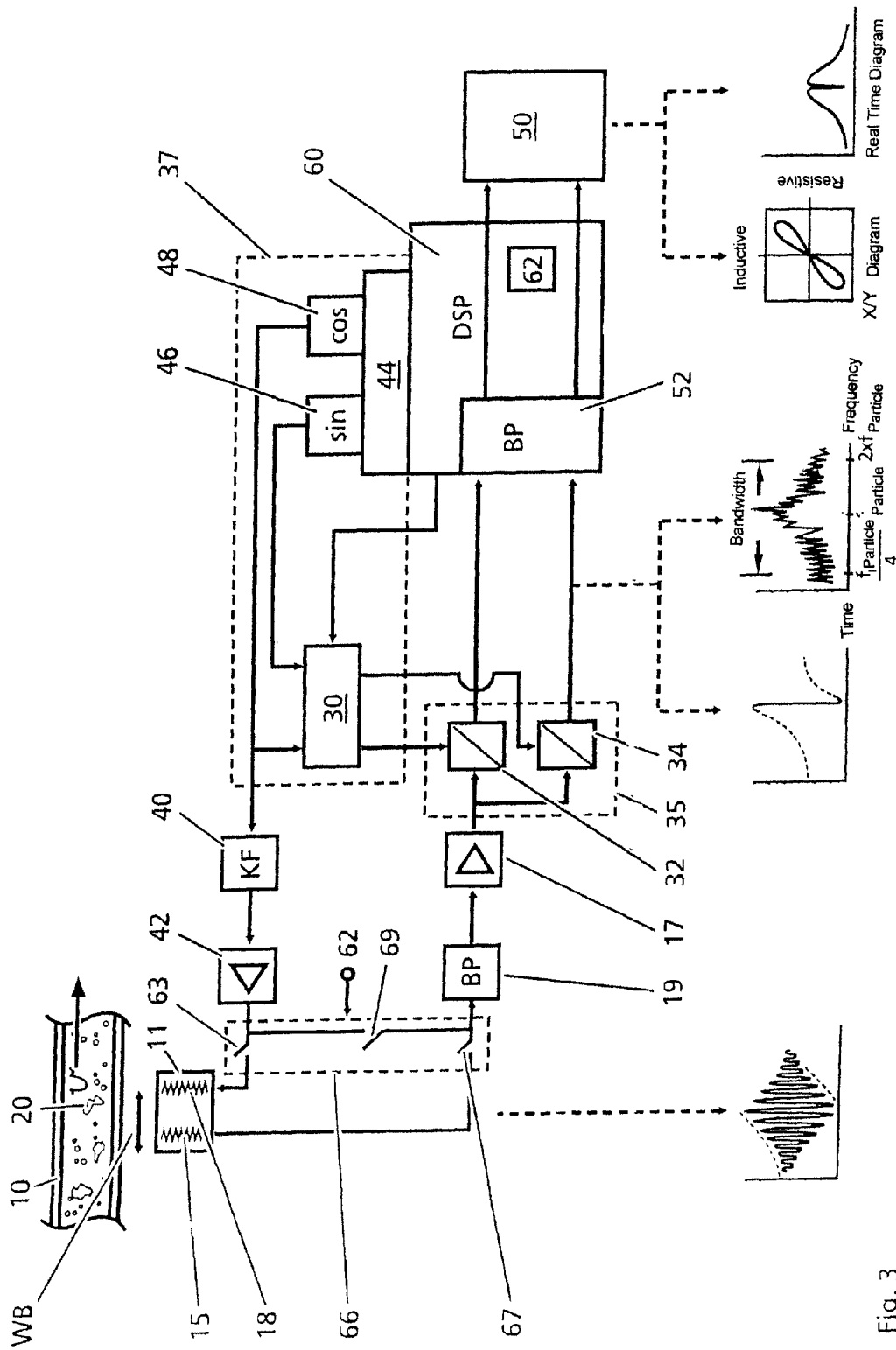


Fig. 3

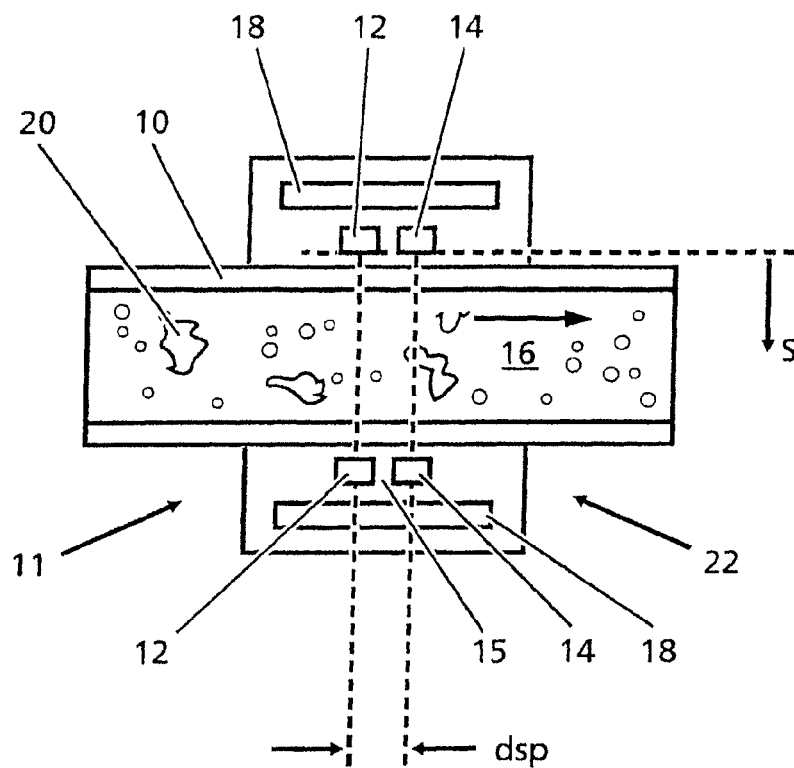


Fig. 4

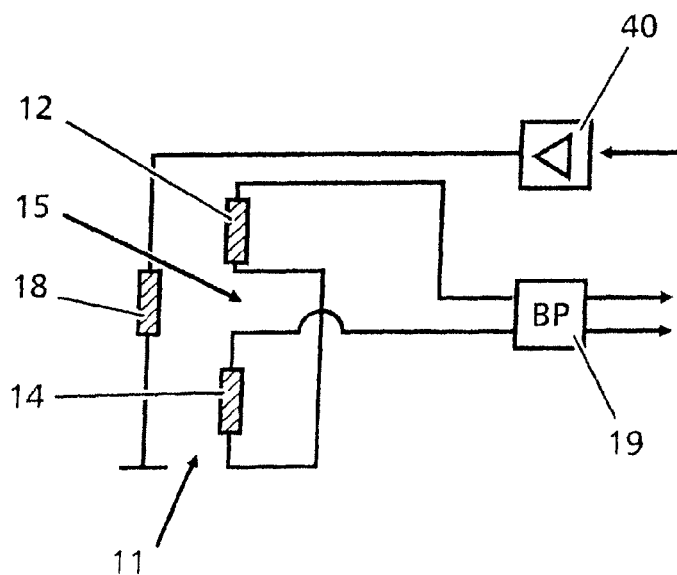


Fig. 5

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DEVICE AND METHOD FOR INDUCTIVE MEASUREMENTS

CROSS REFERENCE TO RELATED APPLICATION

This application is a divisional of co-pending U.S. patent application Ser. No. 12/783,713.

BACKGROUND OF THE INVENTION

1. Field of the Invention

This invention relates to a device and method for nondestructive and noncontact detection of faults in a test piece. In particular, the present invention relates to fault detection using measurements of an eddy current or stray magnetic flux. Furthermore, the invention relates to a device and a method for detecting electrically conductive particles in a liquid flowing in a pipe segment using the eddy currents induced in the particles being detected.

2. Description of Related Art

Conventional nondestructive and noncontact fault detection of faults in a test piece of a semi-finished metallic product is performed by measuring induction and eddy currents in the test piece. In doing so, the test piece is exposed to periodic alternating electromagnetic fields through a sinusoidally energized transmitter coil. The resulting eddy currents induced in the test piece in a coil arrangement are used as a probe and induce a periodic electrical signal, which has a carrier oscillation according to the transmitter carrier frequency whose amplitude and/or phase is modulated by a fault in the test piece when a fault travels into the sensitive region of the probe. Conventionally, when scanning the test piece, the test piece is moved linearly with respect to the probe; however, arrangements with a rotating probe also known. For example, an eddy current measurement device with a linearly advanced test piece is described in U.S. Pat. No. 5,175,498.

Similarly, electrically conductive particles in a liquid, which flows through the coils, cause eddy current losses. These eddy currents can be determined by measuring the impedance change of the coils. In this way electrically conductive particles in a liquid flowing in a pipe can be detected by means of an inductive coil arrangement. This is especially advantageous for detection of the concentration of metallic particles in the lubricant circuit of a machine in order to draw conclusions about the machine state such as measurements of machine wear.

Another conventional measurement method for nondestructive and noncontact detection of faults in a test piece is stray magnetic flux measurement (or stray magnetic field measurement), by means of an induction coil with a magnetic yoke, which magnetizes the test piece resulting in a stray magnetic flux produced by the test piece. The magnetic flux is measured by means of a suitable sensor. Faults in the test piece are detected based on their effects on the stray magnetic flux. One example of this stray flux measurement can be found in U.S. Pat. No. 4,445,088.

In eddy current measurement devices containing probes which rotate around the periphery of the test piece, measuring the distance between the probe head and test piece is performed in order to correct the measurement with respect to the distance because the distance fluctuates during the course of one revolution. The measurement is performed because of decentering or asymmetry of the cross section of the test piece occurs during one revolution. One example of this arrangement can be found in German Patent Application No. 40 03 330 A1.

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International Patent Application Publication WO 2006/007826 A1 discloses an eddy current measurement device with a digital front end, such that the A/D converter stage is triggered with a n -th integral fraction of the frequency of the carrier oscillation, where n is selected depending on the fault frequency, i.e., the quotient of the relative velocity between the test piece and probe and the effective width of the probe.

U.S. Pat. No. 4,209,744 describes an eddy current measurement device which has a test means which simulates signals that are typical of faults in a test piece in order to perform fundamental checking of the electronics. However, only a single amplitude and a primary fault frequency can be simulated. Even if the simulated fault signal were provided with variations, all the electronics cannot be tested. Furthermore, this simulated fault signal cannot be attributed to a certified reference element without dismantling all the electronics and sending them to a laboratory.

International Patent Application Publication WO No. 01/22075 A2 describes an eddy current measurement device within the framework of self-calibration of the system. The intensity of the signal originates from a segment of a test piece without a determining a fault.

GB Patent Application No. 2 192 064 describes an inductive test device where the device is detuned to simulate a fault by a self-test means and by connecting a LED.

SUMMARY OF THE INVENTION

A primary object of this invention is to devise a device and method for nondestructive and noncontact detection, especially by means of eddy current measurement, or stray flux measurement, of faults in a test piece or by detecting electrically conductive particles in a liquid flowing in a pipe segment, to ensure that measurement is as reliable as possible.

This object is achieved by the features of the disclosed embodiments as described herein.

According to aspects of the invention, it is advantageous that, overdriving the A/D converter stage by the receiver coil signal is ascertained by the signal processing unit through monitoring the curve shape of the digitized receiver coil signal, and the part of the receiver coil signal truncated by the A/D converter stage is reconstructed with a mathematical approximation in the digitized receiver coil signal. This feature results in savings in the required hardware, especially since, as a result of signal reconstruction, the demands on the dynamics of the A/D converter are reduced and a more economical A/D converter can be used. Ultimately, the measurement range dictated by the hardware can be expanded by software as a result of this signal reconstruction. Furthermore, when the A/D converter has been overdriven due to the failure of a component, the fault which occurred can still be quantitatively detected through signal reconstruction, enhancing the opportunities for promptly locating faults.

Preferably, the digitized and optionally reconstructed receiver coil signal which is filtered by frequency filters in order to obtain a demodulated useful signal, and the A/D converter stage is triggered with a n -th integral fraction of the frequency of the carrier oscillation of the signal for the transmitter coil arrangement, where n depends on the fault frequency which arises as a quotient of the relative velocity between the test piece and the receiver coil arrangement and the effective width of the receiver coil arrangement, and the frequency filters are set as a function of the fault frequency.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a block diagram of an inductive measurement device with a self-test function and calibration function in accordance with the invention;

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FIG. 2 is a block diagram of an aspect of the invention which is used for detecting faults in a moving test piece;

FIG. 3 is a block diagram of one example of an inductive measurement device according to an aspect of the invention which is used for detecting electrically conductive particles in a flowing liquid;

FIG. 4 schematically illustrates a longitudinal section through a pipe through which a liquid is flowing and which is provided with a transmitter and receiver coil for use with the measurement device as shown in FIG. 3, and

FIG. 5 is a block diagram of the wiring of the coils from FIG. 4.

DETAILED DESCRIPTION OF THE INVENTION

FIG. 1 shows a block diagram of an inductive measurement device with a self-test function and calibration function according to an aspect of the invention. A signal processor 60 communicates with a programmable array logic (PAL) element 68. The PAL element 68 is designed to control the A/D converter and D/A converter. The PAL element 68 also supplies a transmitter coil driver 70 which is provided with a current sensor 72, and delivers the signal for the transmitter coil arrangement (not shown in FIG. 1) of the probe 11 (i.e., measurement head). The receiver coil signal of the receiver coil arrangement (not shown in FIG. 1) of the probe 11 is provided to a low-noise amplifier 74 which is used as a preamplifier. The gain of the low-noise amplifier 74 is controlled or variably set by the processor 60 by way of the PAL element 68. The signal amplified by the amplifier 74 passes through a resonance filter 78 and is supplied to the PAL element 68. The processor 60 for processing, or evaluation, of the signal after digitization in an A/D converter 80, which can be designed to handle 18 bits. In this way, from the receiver coil signal is produced which is then evaluated by an evaluation unit. The evaluation unit can be implemented in the form of the processor 60 and/or externally, for example, as a personal computer (PC) 64.

Furthermore, the system can have a distance sensor 82 with a transmitter coil and a receiver coil (not shown) in order to produce a distance signal from the receiver coil signal of the distance sensor 82. The distance signal constitutes a measure of the distance between the test piece and the probe 11. There is a driver 84 for the transmitter coil of the distance sensor 82 which has a current sensor 86 and which is supplied by the PAL element 68. The receiver coil signal of the distance sensor 82 is supplied to a unit 88 which performs amplification, offset and rectification of the distance signal. The unit 88, like the amplifier 74, is controlled by the PAL element 68. The distance signal is supplied to the PAL element 68, and then to the processor 60 for evaluation by an A/D converter 90, which can be designed to handle 16 bits. Further, there can be several distance sensors 82.

The elements 68, 70, 74, 76, 78, 80, and optionally 60, as well as elements 84, 86, 88, 90 are part of the signal processing unit which produces a signal for evaluation by the evaluation unit from the receiver coil signals.

A self-test unit 62 is implemented in the processor 60. The self-test unit 62 performs systematic quantitative checking of the signal processing functions of the signal processing unit of the front end and systematic quantitative checking of the probe 11 and of the distance sensor 82. Further, the processor 60 performs the checking automatically, at system startup, or at the request of the user interface.

A switch arrangement 66 with three switches 63, 67, 69 is used for monitoring the signal processing unit. The three switches 63, 67, 69 can be actuated by the self-test unit 62 (in

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doing so the switches 63 and 67 are opened and the switch 69 is closed) in order to feed the signal for the transmitter coil of the probe 11 as a periodic input signal into the signal processing unit, i.e., into the input of the amplifier 74 by bypassing the transmitter coil directly.

In the self-test, the self-test unit 62 provides the signal the transmitter coil which is varied with respect to frequency and amplitude in order to check whether the gain of the amplifier 74 is within the required specifications. The gain has been measured and the measured corner frequencies and steepness of the frequency filter 78. A corresponding fault signal is output to the user interface 64, 65, if the specification is not satisfied.

According to aspects of the invention, the device can be made with several channels, then are provided to transmitter coil driver 70, the probe 11 and the self-monitoring switch arrangement 66 is present for each channel and a multiplexer 76 connected upstream of the amplifier 74 (for each transmitter coil there is then its own frequency).

A self-test switch arrangement 92 is isolated between the driver 84 and the unit 88. The self-test switch arrangement 92 has three switches 89, 91, 93 which can be actuated by the self-test unit 62 (in doing so the switches 89 and 91 are opened and the switch 93 is closed) to induce a self-test of the unit 88, or of the A/D converter 90 by a signal output by the transmitter coil driver 84, bypassing the transmitter coil of the distance sensor 82 being sent directly to the input of the unit 88, and by means of the self test unit 62 the frequency and amplitude of the coil driver signal can be systematically varied.

In addition to the output signal of the unit 88, the current signal of the current sensor 72 and the current signal of the current sensor 86 are supplied to the multiplexer 94, which is connected upstream of the A/D converter 90. The sensor current signals are supplied, in this way, to the self-test unit 62 for evaluation. The complex impedance of the respective transmitter coil can be determined and monitored by means of the self-test unit 62 from the transmitter coil current and the transmitter coil voltage detected by current sensors 72 and 86. Also, a fault signal can be optionally output by way of the user interface 64 and 65. As illustrated in FIG. 1, the voltages of the transmitter coil are measured at sites 1, 3 and are supplied to the PAL element by way of the multiplexer 94 and the A/D converter 90.

Furthermore, the offset voltage of the receiver coil of the probe 11 can be monitored by means of the self-test unit 62 (Note: only difference coils have an offset voltage, which arises in any difference coil arrangement since two coils are never exactly identical).

The offset voltage can be eliminated from the receiver signal by means of a high-pass filter. The difference of the voltage before and after the high-pass filter then yields the offset voltage.

Advantageously, the self-test unit 62 is made such that the transmitter coil current and the receiver coil offset voltage are stored as a function of allowing for observation of long-term changes of the transmitter coils and the receiver coils. This monitoring is especially important when the system is designed as an inductive particle counter because the coils cannot be easily dismantled and checked.

Furthermore, the self-test unit 62 is configured such that calibration of the signal processing electronics is enabled by means of a certified calibration standard 96 which can replace the coil 11. The calibration standard 96 is connected to the transmitter coil driver 70 on the input side to the multiplexer 76 and to the amplifier 74 on the output side. When the calibration standard 96 has several reference elements, such

as, different resistances, which are switched over in the course of calibration, the calibration standard 96 has one terminal 98, for example an I²C, which is connected to the processor 60 and the self-test unit 62 for undertaking the corresponding switchovers of the reference elements.

Sites 2, 4 allow for direct measurement of the voltages upstream of the input channels of the amplifier 74 and of the unit 88. Thus, it is possible to directly measure the voltage drop with the calibration standard 96 which was set instead of the corresponding coil, for example.

It is preferable that the calibration standard has at least one RC element with at least one calibrated measurement resistance for checking the precision of the A/D converter of the signal processing electronics. The sampling frequency of the processor 60 can also be checked with the RC element. The measurement resistance of the calibration standard 96 is a lowpass filter to suppress interference. As a reference element, the calibration standard 96 provides for a defined voltage at the input of the A/D converter 80 so that unwanted fluctuations of the sampling frequency are detected.

It is preferable that calibration be performed once a year.

The calibration standard 96 may be a separate unit independent of the measurement device and connected to the measurement device during calibration. This example embodiment is advantageous because the calibration of the calibration standard can be easily checked by a certified calibration laboratory.

Alternatively, the calibration standard 96 can be made as a part of the measurement device such as a component which is provided on a board of the measurement device connected in place of the corresponding coil. This example embodiment has the advantage that the measurement device does not need to be opened for preparation of calibration. However, in this case, the calibration of the calibration standard cannot be checked.

The calibration standard 96 is helpful especially for calibration of the adjustable preamplifier 74. When the calibration standard 96 for economic reasons has only a single or only a few reference resistance values, it is possible to proceed as follows. The RC element of the calibration standard 96 obtains a fixed sinusoidal voltage from the transmitter coil driver 70. The fixed sinusoidal voltage is so large that a sinusoidal signal can be digitally converted with a desired accuracy by means of the A/D converter 80 in the least sensitive position of the amplifier 74. If the gain is increased by means of the PAL element 68, the sine is cut off at some time, and the truncated sine then can be reconstructed again via mathematical approximation, such as a compensation calculation. As a result, the actual amplitude of the signal can be measured. The prerequisite for this method is that the electronics used do not have a latchup effect and the input stage of the A/D converter 80 is protected against destruction by overvoltage.

The following equation of the compensation computation for a sine may be used:

$$A0 \cdot n + A1 \cdot [\sin(x)] + A2 \cdot [\cos(x)] = [y_i]$$

$$A0 \cdot [\sin(x)] + A1 \cdot [\sin^2(x)] + A2 \cdot [\sin(x) \cdot \cos(x)] = [y_i \cdot \sin(x)]$$

$$A0 \cdot [\cos(x)] + A1 \cdot [\sin(x) \cdot \cos(x)] + A2 \cdot \cos^2(x) = [y_i \cdot \cos(x)]$$

where y_i is a measured value such that $y(i) = A0 + A1 \cdot \sin(x) + A2 \cdot \cos(x)$ and $x = 2 \cdot \pi \cdot f \cdot i \cdot dt$, where f indicates the frequency. The brackets stand for summations over the running variable i from zero to n . Those measured values which are outside the allowable range, i.e., the "truncated" values, may

not be used here. The value x represents the current angle, which need not be equidistant.

By computing the amount of $A1$ and $A2$, the original amplitude $A = \sqrt{A1^2 + A2^2}$ and the phase offset $\text{PHI} = \arctan(A2/A1)$ are obtained.

It goes without saying that the described signal reconstruction can be used not only in the checking of the variable amplifier 74, but also in an eddy current test, if as a result of certain circumstances the receiver coil signals arise which override the A/D converter. Ultimately, the measurement range can be expanded using software by this signal reconstruction.

The relatively simple checking of the variable amplifier 74 described above allows for the storage and use of correction values for the respective gain, allowing for more economical and higher quality amplifiers.

There are resonance filters, like the resonance filter (or a combination of high-pass and low-pass filters) 78, allowing for operation with a variable transmitter frequency. The most favorable sampling frequency arising as a function of the velocity of the test piece, effective coil width, and transmitting frequency. As already described, in a self-test using variation of the frequency and amplitude of the input voltage, the corner frequencies and the edge steepness of the filters can be determined.

Changes of the sensor hardware, especially damage, can be ascertained early by the described impedance measurements of the transmitter and receiver windings using the self-test unit 62 so that test times with damaged sensor hardware can be avoided as much as possible. As a result, measurement becomes more reliable.

The described measurement of the receiver coil offset voltage by the self-test unit 62 enables early detection of overdriving problems, for example, in conjunction with certain test piece materials. This allows for preventive reactions to problems and increases in the reliability of the test.

The possibility of calibration of the system by means of the self-test unit 62 and the calibration standard 96 enables simple calibration of the system on site, eliminating the necessity of installation and dismounting of a test adapter in the system. As a result, production and servicing of the system is more economical.

The calibration standard 96, itself, if it is made as a separate unit, can of course also be calibrated at regular intervals by a certified calibration laboratory, as previously described.

FIG. 2 illustrates a block diagram of an example of an inductive measurement device according to an aspect of the claimed invention which is used for detecting faults in a moving test piece and a digital demodulation method. Aside from the self-test function and signal reconstruction, this device is described in International Patent Application Publication WO 2006/007826 A1. Here, a test piece 13 in the form of a semi-finished industrial article, for example, a slab, which is tested when it moves linearly with a variable velocity v passed the probe 11. The velocity is detected with a velocity detector 21 which can deliver, for example, a signal essentially proportional to the velocity v . The signal can be, for example, a rectangular signal (possibly also two-track in order to be able to distinguish forward and backward) which contains one pulse, for example, per 5 mm advance of the test piece 13.

The probe 11 has a transmitter in the form of a transmitter coil 18 and a receiving coil 15. With an alternating electromagnetic field with at least one given carrier frequency, the transmitter coil 18 is used to induce eddy currents in the test piece 13 in the receiving coil 15 and in turn induce an AC voltage which acts as a probe signal and has a carrier oscil-

lation with the carrier frequency of the transmitter coil **18**. The amplitude and the phase of the probe signal is modulated by a fault **23** when the fault **23** travels into the effective width WB of the receiving coil **15**. The receiving coil **15** is preferably made as a difference coil, i.e., a coil with two windings which are wound in the opposite direction, and react only to changes of the electrical properties due to the presence of a fault **23** of the test piece. Difference coils are suitable mainly for detection of sudden changes in the test piece **13**. An absolute coil can also be used as the receiving coil **15** which comprises several windings wound in the same direction, and suitable especially for detection of long homogeneous changes in the test piece **13**.

The voltage for the transmitter coil **18** can be produced by a binary signal produced by a timer unit **44** and delivered to a generator **48** as the input frequency which produces a rectangular signal and a sinusoidal signal which travels through the curve shaper **40** and then is amplified by a power amplifier **42** before being sent to the transmitter coil **18**. Preferably, the signal has a sinusoidal shape and in the simplest case contains only a single carrier frequency, but measurements with several carrier frequencies at the same time and/or carrier signals which differ distinctly from sinusoidal oscillations is also possible. Typically the carrier frequency is in the range from 1 kHz to 5 MHz.

Fundamentally, the transmitter coil can also be operated with a digital signal based on the pulse duration modulation greatly reducing the power loss in the driver stage.

The probe signal received by the receiving coil **15** travels through a bandpass filter **19** and an adjustable preamplifier **17** before being supplied to an A/D converter stage **35**. The bandpass filter **19** is used, on the one hand, as an (anti-) aliasing filter with respect to signal digitization by the A/D converter stage **35**, and on the other hand, to mask out high frequency and low frequency noise signals. The adjustable preamplifier **17** is used to bring the amplitude of the analog probe signal to the amplitude optimally suitable for A/D converter stage **35**.

The A/D converter stage **35** has two A/D converters **32, 34** which are connected in parallel and have high resolution with at least a resolution of 16 bits, preferably 22 bits. It is also preferable that the A/D converter stage **35** is able to carry out at least 500 A/D conversions per second. The A/D converters **32, 34** are preferably flash converters or SAR (successive approximation register) converters.

The version with two A/D converters is one example. It is important that the fault signal is orthogonally sampled, which may also be performed with only one converter.

The A/D converter stage **35** is triggered by a trigger means **37**, which has the aforementioned timer unit **44**, a cosine generator **48**, a sine generator **46** located parallel to the sine generator **48**, and a frequency divider **30**. The signal which has been generated by the cosine generator **48** and which has the frequency of the carrier frequency of the supply signal of the transmitter coil **18** is provided to the frequency divider **30**. The signal of the sine generator **46** which corresponds to the signal of the cosine generator **48**, but with a phase-shift of 90° thereto, is also provided to frequency divider **30**. In the frequency divider **30** these two signals are divided with respect to their frequency by a whole number n . The corresponding frequency-reduced output signal is used to trigger the A/D converter **32** and the A/D converter **34**. The selection of the number n for the divider **30** is undertaken by a digital signal processor **60** depending on the fault frequency, i.e., the quotient of the current velocity of the test piece v and the effective width WB of the receiving coil **15**. Preferably, n is chosen to be inversely proportional to the main fault frequency in order

for the trigger rate of the A/D converter stage **35** to be at least roughly proportional to the main fault frequency. This results in that if the effective width WB in the first approximation is assumed to be constant, at a higher test piece velocity v and thus a high fault frequency the analog probe signal is sampled more frequently.

Preferably, the divider **30** is made as a so-called PAL (Programmable Array Logic) component in order to ensure that the trigger signals arrive synchronously, to the output signal of the cosine generator **48** and the sine generator **46** without phase jitter at the A/D converter stage **35**.

Due to the corresponding phase shift of the two input signals of the divider **30**, the two A/D converters **32, 34** are also triggered with a fixed phase offset of 90°. In this way the analog probe signal can be evaluated in a two-component manner, i.e., with respect to amplitude and phase. It goes without saying that the phase delay between the trigger signal of the A/D converter signal **35** and the signal of the transmitter coil **18** should be as small as possible, and especially so-called phase jitter should also be avoided, i.e., the phase relations should be constant in time as exactly as possible.

With the illustrated trigger means **37**, the analog probe signal is sampled by each A/D converter **32, 34** at least once per full wave of the carrier oscillation (in this case n is equal to 1). Depending on the current fault frequency, i.e., the velocity of the test piece v , n can be much larger than 1 so that sampling only in each n -th full wave of the carrier oscillation.

As already mentioned, what matters is that sampling is taken orthogonally. When sampling is done at 0° and 90° the complex components of the fault signal are obtained. At 180° and 270° the same components are obtained, but in the inverse to those taken at 0° and 90°. By inverting these components an average can be formed and thus an increased sampling rate can be used. Such sampling methods have advantages with respect to noise and design of the input filter.

The demodulated, digital, two-channel output signal of the A/D converter stage **35** travels through a digital bandpass filter **52** of the signal processor **60**. The digital bandpass filter **52** is used to mask out noise signals outside the bandwidth of the fault signal. For this purpose, the corner frequency of the high-pass filter (software filter) is preferably chosen such that it is less than one fourth of the fault frequency, while the corner frequency of the low-pass filter is preferably chosen such that it is at least twice the fault frequency to avoid masking out the signal portions which still contain information of the fault.

The digital bandpass **52** is clocked with the sampling rate of the A/D converter stage **35**, i.e., the trigger rate, which is an advantage that the corner frequencies of the bandpass. When the fault frequency changes, i.e., when the velocity of the test piece v changes, the trigger rate are automatically entrained with the fault frequency since the corner frequencies of a digital bandpass filter are proportional to the clock rate and the clock rate is automatically adapted to the change of the fault frequency by way of the sampling rate which is stipulated by the trigger unit **37**.

This also applies analogously when the transmission frequency has been changed reducing the cost of digital filtration with respect to different types of filter stages.

The information necessary for determining the main fault frequency with respect to the effective width WB can be either manually input to the signal processor **60** made available directly by the probe **11**, as described, for example, in European Patent Application No. 0 734 522 B1.

It goes without saying that the measurement system reacts analogously to the change of the fault frequency caused by the

constant velocity v of the test piece, but the receiving coil **15** is replaced by another with a different effective width WB .

The useful signal is obtained after filtration by the digital bandpass filter **52** is evaluated in a known manner by an evaluation unit **50** in order to detect and locate faults **23** of the test piece **13**. For detection both the amplitude information and the phase information of the fault signal is used.

In particular, for relatively large values of n , i.e., when only a relatively small number of full waves of the carrier oscillation are sampled during the sampling pauses, the transmitter coil **15** and/or the evaluation electronics, especially the signal processor **60**, can be turned off or put on stand-by in order to reduce power consumption such capability is important especially for portable measurement devices.

In the processor **60** the self-test unit **62** for the monitoring and calibration functions named above in conjunction with FIG. **1** are implemented. Thus, the self-test unit **62** controls the switch arrangement **66** with three switches **63**, **67**, **69** in order to feed the signal for the transmitter coil **18** of the probe **11** bypassing the transmitter coil **18** and the receiver coil **15** directly as a periodic input signal into the signal processing, i.e., into the input of the bandpass filter **19**.

FIGS. **3** to **5** show an example of an inductive measurement device according to an aspect of the claimed invention used to detect electrically conductive particles in a flowing liquid using a digital demodulation method. Aside from the self-test function, this device is described in U.S. Patent Application Publication No. 2009/0051350. Fundamentally, the signal processing, especially the signal reconstruction when the A/D converter is being overdriven, and the self-test functions are performed analogously to the above described approach shown in FIG. **2**.

As shown in FIG. **4**, a pipe segment **10** is surrounded by a first inductive receiver coil **12** and a second inductive receiver coil **14** which spaced apart from the receiver coil **12** in the axial direction so that a liquid **16** flowing in the pipe segment **10** flows through the coils **12**, **14** in the axial direction. The axial distance of the two coils **12**, **14** and the axial dimensions of the coils **12**, **14** are, for example, 2 mm. The two receiver coils **12**, **14** are surrounded on the outside by a transmitting coil **18** which is located coaxially to the two coils **12**, **14** and has a larger diameter than coils **12**, **14**. The axial dimensioning of the transmitter coil **18** is such that the two receiver coils **12**, **14** are located completely within the transmitter coil **18**. Preferably, the extension of the transmitter coil **18** in the axial direction is at least twice as great as the axial extension of the arrangement of the receiver coils **12**, **14**, i.e., the distance plus the axial extension of the coils **12**, **14**. The coils **12**, **14**, **18** are located in a housing **22** which surrounds the pipe segment **10** and form a probe **11**.

Typically, the pipe segment **10** is part of the lubricant circuit of a machine, then, the liquid **16**, for example, is a lubricant containing metal particles which are typically abrasion from moving parts of the machine. A typical value for the lubricant flow rate in the main flow is 10 liters/min. At much higher flow rates it is advantageous to measure a secondary flow, instead of the main flow rate.

As shown in FIG. **5**, the two receiver coils **12**, **14** are connected subtractively as a difference coil **15**, i.e., they are arranged in an opposite direction, so that a voltage with the same amount but with opposite signs is induced in the two coils **12**, **14**. The transmitter coils **18** and the receiver coils **12**, **14** form a transformer arrangement, where the transmitter coil **18** forms the primary side and the receiver coils **12**, **14** forms the secondary side. The transformer core is formed by the

materials or media fed through the coils **12**, **14**, **18**, e.g., air, the housing **22**, the pipe **10**, and the liquid **16** with the particles **20**.

The impedance difference of the coils **12**, **14** caused by the particles **20**, i.e. the difference of the impedance of the two coils **12**, **14** caused by the instantaneous presence of a particle **20** in one of the two coils **12**, **14** (the particles **20** are much smaller than the distance of the coils **12**, **14**), is imaged by the measurement signal output by the coils **12** and **14**.

FIG. **3** shows an example of the structure of the eddy current measurement device that uses the probe **11** according to an aspect of the present invention.

A transmitter coil **18** is used, by means of an alternating electromagnetic field with at least one given carrier frequency, to induce eddy currents in the particles **20**, which in turn induce an AC voltage that acts as the probe signal in the receiving coil **15**. The receiving coil **15** is a difference coil and with a voltage having a carrier oscillation with the carrier frequency of the transmitter coil **18**. The amplitude and the phase of the probe signal are modulated by a particle **20** when the latter travels into the effective width WB of the receiving coil **15**.

The voltage of the transmitter coil **18** can be produced, for example, by a binary signal produced by a timer unit **44** input to a generator **48** producing a rectangular signal and a sinusoidal signal, which travels through the curve shaper **40** and then is amplified by a power amplifier **42** before being sent to the transmitter coil **18**. Preferably the signal has a sinusoidal shape and in the simplest case contains only a single carrier frequency, but maybe several carrier frequencies at the same time and/or carrier signals which differ distinctly from sinusoidal oscillations. Typically the carrier frequency is in the range from 5 kHz to 1 MHz.

The probe signal received by the receiving coil **15** travels through a bandpass filter **19** and an adjustable preamplifier **17** before being supplied to an A/D converter stage **35**. The bandpass filter **19** is used, on the one hand, by means of a low-pass filter as an (anti-aliasing) filter with respect to signal digitization by the A/D converter stage **35**, and on the other hand, by means of a high-pass to mask out high and low frequency noise signals. The adjustable preamplifier **17** is used to bring the amplitude of the analog probe signal to the amplitude optimally suitable for the A/D converter stage **35**.

The A/D converter stage **35** has two A/D converters **32**, **34** which are connected in parallel and have high resolution with a resolution of 16 bits, preferably at least 22 bits, and are able to carry out at least 500 A/D conversions per second. The A/D converters **32**, **34** are preferably made as flash converters or SAR (successive approximation register) converters.

If offset voltage compensation takes place by means of an additional D/A converter and subtractor, a resolution of the A/D converter of 12 bits is sufficient.

The A/D converter stage **35** is triggered by a trigger means **37** which has the aforementioned timer unit **44**, the cosine generator **48**, the sine generator **46** which is located parallel to the cosine generator **48**, and the frequency divider **30**. A signal is provided to the frequency divider **30**. The signal has been generated by the cosine generator **48** and has the frequency of the carrier frequency of the supply signal of the transmitter coil **18**, and the signal of the sine generator **46** which corresponds to the signal of the cosine generator **48**, but which is phase-shifted by 90° to with respect to the signal of the sine generator **46**. In the frequency divider **30** these two signals are divided with respect to their frequency by a whole number n . The corresponding frequency-reduced output signal is used to trigger the A/D converter **32** and the A/D converter **34**. The selection of the number n for the divider **30**

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is undertaken by a digital signal processor 60 depending on the particle frequency, i.e., which as the quotient of the flow velocity v of the liquid 16, the velocity v of the particles 20, and the effective width WB of the receiving coil 15. Preferably, n is chosen to be inversely proportional to the particle frequency in order for the trigger rate of the A/D converter stage 35 to be at least roughly proportional to the particle frequency. Therefore, if the effective width WB in the first approximation is assumed to be constant, at a higher flow/particle velocity v and thus higher particle frequency the analog probe signal is sampled more frequently.

Preferably, the divider 30 is made as a so-called PAL (Programmable Array Logic) component in order to ensure that the trigger signals arrive as synchronously with the output signal of the cosine generator 48 and the sine generator 46 and without phase jitter at the A/D converter stage 35.

Due to the corresponding phase shift of the two input signals of the divider 30, the two A/D converters 32, 34 are also triggered with a fixed phase offset of 90° . In this way, the analog probe signal can be evaluated in a two-component manner, i.e., both with respect to amplitude and phase. It goes without saying that the phase delay between the trigger signal of the A/D converter signal 35 and the signal of the transmitter coil 18 should be as small as possible, and especially so-called phase jitter should also be avoided, i.e., the phase relations should be as constant in time as possible.

It is ensured that the analog probe signal is sampled by each A/D converter 32 and 34 at most once per full wave of the carrier oscillation (in this case n is equal to 1) with the illustrated trigger means 37. Depending on the current fault frequency, i.e., the velocity of the test piece v , n however can be much greater than 1 so that sampling only takes place at each n -th full wave of the carrier oscillation.

Since sampling takes place at most once per full wave per A/D converter 32, 34, the frequency of the carrier oscillation, i.e., the carrier frequency, is eliminated from the digital signal by this undersampling, i.e., demodulation of the analog probe signal takes place by means of undersampling.

Preferably, n is chosen such that a noticeable particle signal is observed in the time interval. That is, a time interval is chosen such that one point of a particle 20 moves through the effective width WB of the receiving coil 15 the time interval which corresponds essentially to the inverse of the main particle frequency, which is at least 5, preferably at least 20 samples are taken by each A/D converter 32 and 34 to obtain the information contained in the particle signal sufficient for reliable particle detection. Generally however, not more than 50, at most 100, samplings will be necessary during this time interval, a minimum of 10 samplings.

The frequency of the carrier oscillation should be chosen such that it is at least ten times the particle frequency, since otherwise the particle signal is carried by too few full waves of the carrier oscillation and the reproducibility of particle detection becomes a problem.

The demodulated, digital, two-channel output signal of the A/D converter stage 35 travels through a digital bandpass filter 52 may be contained in the signal processor 60 and used to mask out noise signals which are outside the bandwidth of the particle signal. For this purpose, the corner frequency of the high-pass filter is preferably chosen such that the corner frequency is less than one fourth of the particle frequency, while the corner frequency of the low-pass filter is preferably chosen such that it is at least twice the particle frequency in order to avoid masking out the signal portions which still contain information with respect to particle passage.

The digital bandpass filter 52 is clocked with the sampling rate of the A/D converter stage 35, i.e., the trigger rate; this

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entails the major advantage that the corner frequencies of the bandpass filter when the particle frequency changes, i.e., when the velocity of the particles v changes, are automatically entrained with the particle frequency since the corner frequencies of a digital bandpass filter are proportional to the clock rate which is automatically adapted to the change of the particle frequency by way of the sampling rate which is stipulated by the trigger unit 37.

The information which is necessary for determining the main particle frequency with respect to the effective width WB can be either input manually to the signal processor 60 or provided directly by the measurement head 11, as is described, for example, in European Patent Application No. 0 734 522 B1 and corresponding to International Patent Application Publication. No. WO 95/16912.

It goes without saying that the measurement system reacts analogously to the change of the particle frequency which is caused by the particle velocity v being kept constant, but the receiving coil 15 is replaced by another with a different effective width WB.

In particular, for relatively large values of n , i.e., when only a relatively small number of full waves of the carrier oscillation at all is sampled, during the sampling pauses for example the transmitter coil 18 and/or the evaluation electronics, i.e., especially the signal processor 60, can be turned off or put on stand-by in order to reduce power consumption. This is important especially for portable measurement devices.

The useful signal obtained after filtration by the digital bandpass filter 52 is evaluated in an evaluation unit 50 in order to detect the passage of particles 20 using the amplitude and phase information of the particle signal.

Advantageously, the evaluation unit 50 is made such that the detected particle passages are counted so that conclusions can be made about the particle concentration in the liquid 16, and the state of the machine.

Fundamentally, in a difference coil, as a result of difference formation (the individual coils of the difference coil are never exactly alike in practice), the so-called coil offset voltage arises that can exceed the actual fault signal by several orders of amplitude, for example, by 100 to 30000 times. The resulting relatively large amplitude of the receiver coil signal compared to the actual useful signal imposes high demands on the electronics, especially on the A/D converter on its resolution.

Monitoring and calibration functions, which are named above in conjunction with FIG. 1, are implemented in the self-test unit 62 of the processor 60. Thus, the self-test unit 62 controls the switch arrangement 66 with three switches 63, 67, 69 in order to feed the signal for the transmitter coil 18 of the probe 11 by bypassing the transmitter coil 18 and the receiver coil 15 directly as a periodic input signal into the signal processing, i.e., into the input of the bandpass filter 19.

What is claimed is:

1. A method for nondestructive and noncontact detection of faults in a test piece which is moving relative to the device, comprising:

exposing the test piece to a plurality of periodic alternating electromagnetic fields with a transmitter coil arrangement;

detecting a periodic electrical signal with a receiver coil arrangement, such that the periodic electrical signal has a carrier oscillation where at least one of an amplitude and a phase is modulated by a fault in the test piece when the fault is detected by the receiver coil arrangement;

digitizing the receiver coil signal with an A/D converter stage;

producing a useful signal from the digitized receiver coil signal with a signal processing unit;

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evaluating the useful signal with an evaluation unit for detecting a fault in the test piece;
 monitoring a curve shape of the digitized received coil signal when overdriving the A/D converter stage by the receiver coil signal is ascertained by the signal processing unit, 5
 truncating a part of the receiver coil signal with the A/D converter stage; and
 reconstructing the receiver coil signal with a mathematical approximation in the digitized receiver coil signal. 10

2. A method as claimed in claim 1, further comprising triggering the A/D converter stage;
 filtering the digitized and reconstructed receiver coil signal with a plurality of frequency filters to obtain a demodulated useful signal; and 15
 triggering the A/D converter stage with a n-th integral fraction of a frequency of the carrier oscillation of the signal for the transmitter coil arrangement.

3. A method as claimed in claim 2, wherein n is chosen depending on a fault frequency which arises as a quotient of a relative velocity between the test piece and the receiver coil arrangement and the effective width of the receiver coil arrangement, and 20
 wherein the plurality of frequency filters are set as a function of the fault frequency.

4. A device for nondestructive and noncontact detection of faults in a test piece which is moving relative to the device, with a transmitter coil arrangement with at least one transmitter coil for exposing the test piece to a plurality of periodic alternating electromagnetic fields, comprising: 25
 a receiver coil arrangement with at least one receiver coil for detecting a periodic electrical signal which has a carrier oscillation where at least one of an amplitude and a phase is modulated by a fault in the test piece when a fault is detected by the receiver coil arrangement;
 an A/D converter stage for digitizing a receiver coil signal; 30
 a signal processing unit for producing a useful signal from the digitized receiver coil signal; and
 an evaluation unit for evaluating the useful signal for detection of the fault in the test piece, 35
 wherein the signal processing unit reconstructs a part of the receiver coil signal truncated by the A/D converter stage 40

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with a mathematical approximation in the digitized receiver coil signal when overdriving of the A/D converter stage by the receiver coil signal is ascertained by monitoring a curve shape of the digitized receiver coil signal by the signal processing unit.

5. A device as claimed in claim 4, wherein the device further comprises a plurality of channels, wherein the transmitter coil arrangement and the receiver coil arrangement each comprise a plurality of coils which are each assigned to one certain measurement frequency.

6. A device as claimed in claim 4, wherein the A/D converter stage is provided with overvoltage protection with respect to the input.

7. A device as claimed in claim 4, further comprising a self-test unit which performs systematic and quantitative check with automatically or upon an external request of at least one of a plurality of signal processing functions of the signal processing unit, the transmitter coil arrangement, and the receiver coil arrangement, and upon external request to undertake calibration of the signal processing unit with a calibration standard which replaces at least one of the transmitter coil arrangement and the receiver coil arrangement.

8. A device as claimed in claim 7, wherein the self-test unit switches the signal processing unit for checking the signal processing functions such that a signal for the transmitter coil arrangement is fed directly as a periodic input signal into the signal processing unit, and the signal is systematically varied by the self-test unit.

9. A device as claimed in claim 8, wherein the signal processing unit comprises a plurality of amplifiers and a plurality of frequency filters, 35
 wherein the self-test unit is adapted to check whether a measured gain of the amplifier, a measured corner frequencies, and steepness of the frequency filters are within a given specification by means of variation of a frequency and an amplitude of the signal for the transmitter coil arrangement, and to output a fault signal if the specification is not satisfied. 40

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